

Work Order ID 63002

Friday, October 15, 2010 9:46:41 AM

Page 1

Item ID: D3442-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Shim

Start Date: 10/15/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 10/21/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3442

Rev A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3442

Dwg Rev: A

Prog Rev: L

2-Deburr if necessary

B10-0-8

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B10-0-8

120

0.00



QC

QC8- Inspect parts - second check

Memo

SM-03

0.00

Quality Control

12

10/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63002

Friday, October 15, 2010 9:46:42 AM



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Item ID:	D3442-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Shim				Stop	
Start Date:	10/15/2010	Start Qty:	12.00			
Required Date:	10/21/2010	Req'd Qty:	12.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
Packaging	Memo	0.00							
Packaging	*****STOCK IN BASKET CELL*****								

N/A
Fluor
due 2 water set.

SAB
10-10-19

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D3442-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Shim

Start Date: 10/15/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 10/21/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/10/20

CMF

10-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Friday, October 15, 2010 9:46:46 AM

Page 1

Work Order ID: 63002

Parent Item: D3442-1

Parent Item Name: Shim




Start Date: 10/15/2010

Required Date: 10/21/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A□05.09.02□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA  304/316 .032 Sheet		Purchased	No			100	sf	91.0896	0.04	0.505263			

1810-10-18

Location

Loc Qty

Loc Code

MAT20

91.0896

109023

30.2896

109057

60.8

109057



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

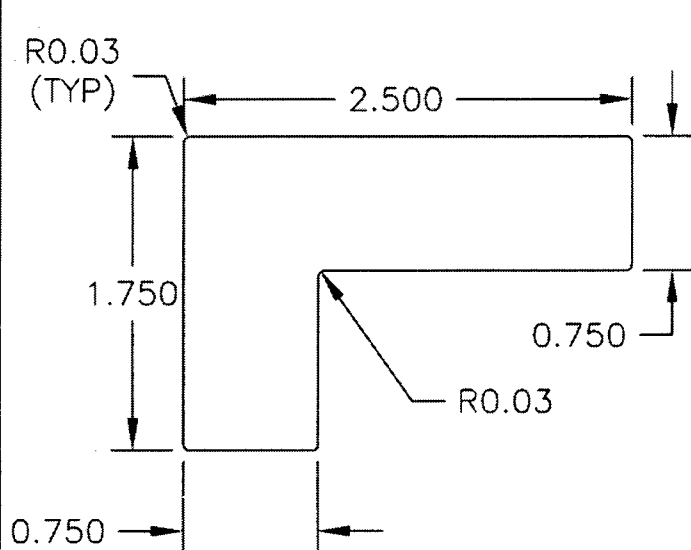
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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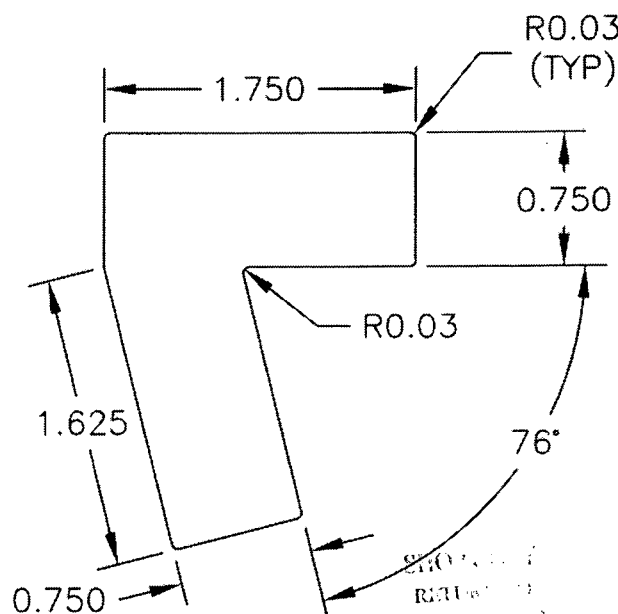
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3442	REV. A SHEET 1 OF 1
DATE 05.06.03		TITLE SHIM	SCALE 1:1
A	05.06.03	NEW ISSUE	



D3442-1

D3442-1/-3 SHIM

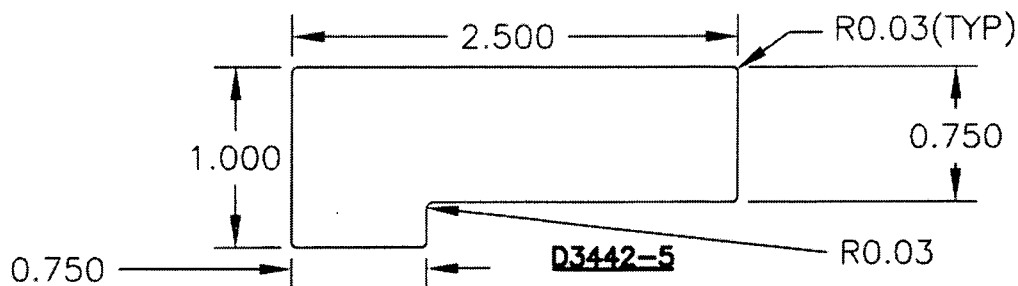
- 1) MATERIAL: AISI 304/316 SS SHEET 21 GAUGE (0.034 THICK)
(REF DART SPEC M304S21GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3442-3

UNCONTROLLED
SUBJECT TO
WITHOUT
WORKING
NO. 03002

8/10-10-11



D3442-5

D3442-5 SHIM

- 1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.08.19 *[Signature]*

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